

Work Order ID 164608

Tuesday, July 25, 2017 7:52:54 AM

164608

Page 1

Item ID: D4956-21 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Center
Start Date: 7/17/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/21/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: JUL 25 2017 Tooling: _____ Date: _____
QC: DAS Date: _____ SPC (Y/N): _____ Date: _____
21
9-89 Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4956	A

100 0.00
100
Waterjet
FLOW CNC Waterjet
Memo
1-Cut as per Dwg
Dwg Rev: A
Prog Rev: A
2-Deburr if necessary
0.73
④ 07/26/17

110 0.00
110
QC
Quality Control
Memo
QC2- Inspect parts off machine FAI/FAIB
0.04
④ 07/26/17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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OTHER : ☐					

Work Order ID 164608

Tuesday, July 25, 2017 7:52:54 AM

164608

Page 4

Item ID: D4956-21 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Center
Start Date: 7/17/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/21/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.40							
Quality Control									

DAS
21
9-89

AUG 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Picklist Print

Tuesday, July 25, 2017 7:52:57 AM

Page 1

Work Order ID: 164608

164608

Parent Item: D4956-21

D4956-21

Parent Item Name: Wearplate Center

Start Date: 7/17/2017

Required Date: 7/21/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA		Purchased		No		100	sf	52.8000	0.84	3.536842			
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M304S20GA

304/316 .040 Sheet

**

2-17/07/20

Location

Loc Qty

Loc Code

MAT020

52.8

m137513

15.3

m137762

8.7

m137980

28.8

2.8

1

DQA: _____ Date: _____

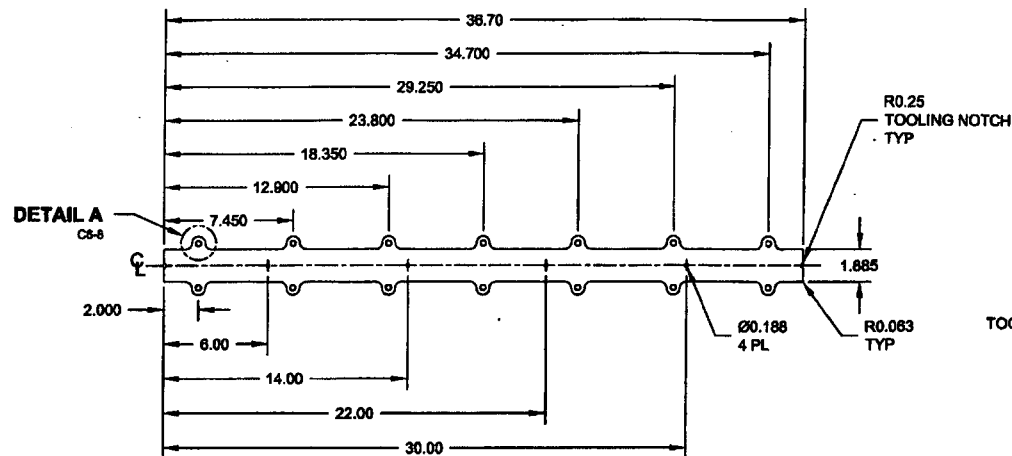


WORK ORDER NON-CONFORMANCE / UPDATE

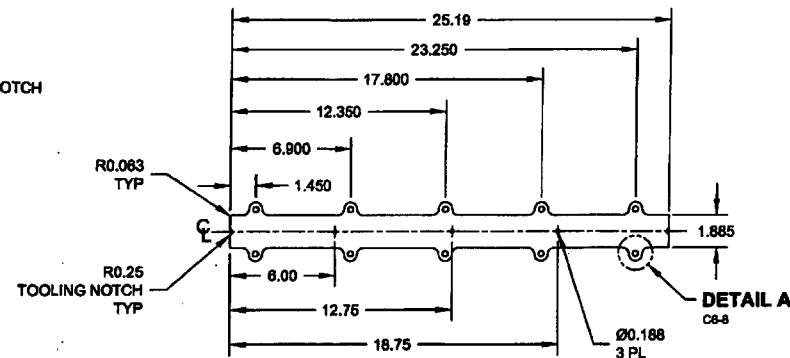
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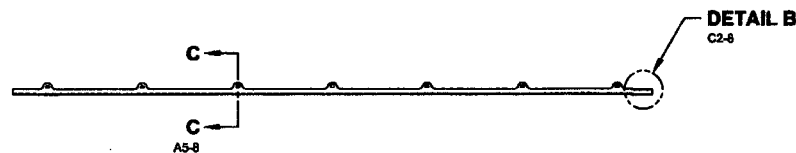
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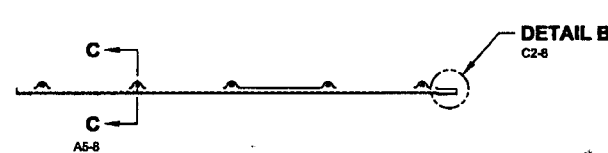
D4956-21F FLAT PATTERN



D4956-25F FLAT PATTERN



D4956-21 WEARSHOE
(MAKE FROM D4956-21F)



D4956-25 WEARSHOE
(MAKE FROM D4956-25F)

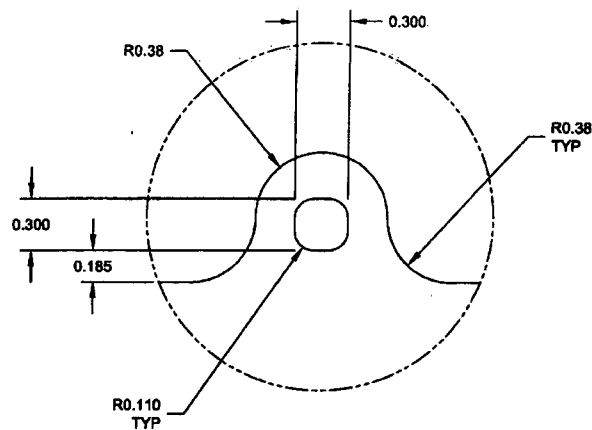
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4956-21 = 0.82 lbs; D4956-25 = 0.58 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

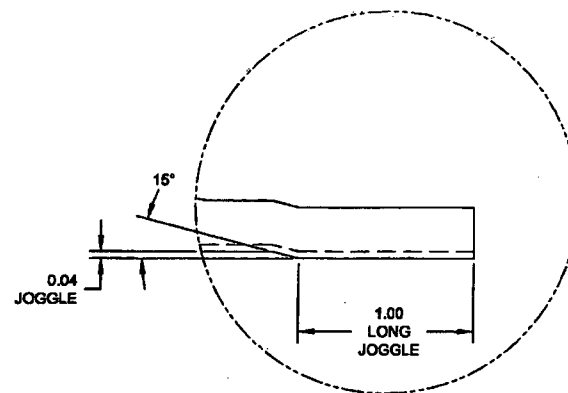
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UNCONTROLLED COPY
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WITHOUT NOTICE
WORK ORDER
NO. *164608 MJS*
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2014-04-17
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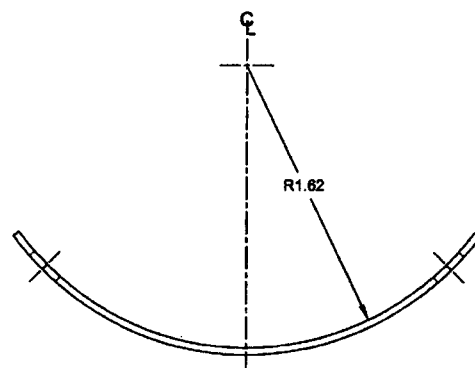
DESIGN	J	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	J	DRAWING NO.	REV. A
CHECKED	AP	D4956	SHEET 3 OF 8
MFG. APPR.	AS	TITLE	SCALE
APPROVED	12	WEARSHOE	NTS
DE APPR.	12	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	13.09.26		



DETAIL A C8-1 C4-1
C8-2 C1-3
C8-3 C1-3
C2-4
C8-5 C2-6
C8-6 C2-6
C4-7 C3-7



DETAIL B B6-1 B2-1
B3-2
B5-3 B1-3
B2-4
B4-7 B1-7



SECTION C-C B7-1 B3-1
B5-2
B7-3 B3-3
B8-4
B7-5 B3-5
B7-6 B3-6
B7-7 B3-7

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2014-04-17
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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